Work Order ID 119413 *119413* Page 1 Thursday, May 15, 2014 3:59:59 PM **Item ID:** D3571-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Stop Guide **Start Date:** 5/15/14 Start Qty: 8.00 **Cust Item ID:** Required Date: 5/15/14 Req'd Qty: 8.00 **Customer:** Reference: Start Run Approvals: Process Plan: MLJ Date: 14-05-2 (Tooling: Date: Stop Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID **Description Run Hours** Code Qty **Oty** Number Stamp **Draw Nbr Revision Nbr** D3571 Rev A 0.00 MH **BAND SAW** *100* Bandsaw 0.00 Memo 14/05/26 Jeaspa Bandsaw Cut blank 2.90 " long 110 0.00 HAAS CNC VERTICAL MACHINING #1 *110* HAAS 1 0.00 HAAS CNC vertical machine #1 1- Mill as per Folio FA675Rev: _______ & Dwg D3571 Rev: ______ 2-Deburr per dwg D3571 120 QC2- Inspect parts off machine FAI/FAIB 0.00 *120*

0.00

Memo

Quality Control

DQA:			Date:							TOACT					
						WORK ORDER NON-	-CC	ONFORMANCE / UPDATE							
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Work Order ID 119413 *119413* Page 2 Thursday, May 15, 2014 3:59:59 PM Item ID: D3571-1 Accept *N900040100* Setup Start **Revision ID: Item Name:** Stop Guide **Start Date:** 5/15/14 **Start Qty:** 8.00 *8* **Cust Item ID:** Required Date: 5/15/14 Req'd Qty: 8.00 *****2* **Customer:** Reference: Start Run **Approvals: Process Plan:** Date: Tooling: Date: Stop QC: Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Reject Accept Reject Insp. **Work Center ID Description Run Hours** Code Qty Number **Qty** Stamp 130 al 14/05/30 QC8- Inspect parts - second check 0.00 *130* 0.00 Memo Quality Control 140 Chemical Conversion Coat per QSI005 4.1 0.00 *140* 8 76 146.2 HandFinish 0.00 Memo Hand Finishing

150

150 Powdercoat

Powder Coating

Memo FINISH TIME:

OVEN TEMPERATURE:

0.00

0.00

8 \$ 14-6-31

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						WORK ORDER NON	-CC	ONFO	RMANCE / UPDA					AEROSPACE
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1 3		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					

Work Order ID 119413 *119413* Page 3 Thursday, May 15, 2014 3:59:59 PM **Item ID:** D3571-1 Accept *N900040100* Setup Start **Revision ID: Item Name:** Guide Stop **Start Date:** 5/15/14 Start Oty: 8.00 *****8* **Cust Item ID:** Required Date: 5/15/14 Req'd Qty: 8.00 **Customer:** Reference: Run Start Process Plan: _____ **Approvals:** Date: Tooling: Date: Stop OC: Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description Run Hours Qty Code Qty Number Stamp 160 QC3- Inspect Part Finish 0.00 *160* 0.00 Memo Quality Control 170 Identify as per dwg & Stock Location: 57050 *170* JUN 0 3 2014 Packaging 0.00 Memo **Packaging** 180 QC21- Final Inspection - Work Order Release 0.00 *120* MUJ 1406-04 0.00 Memo **Quality Control**

JH14-6-4

DQA: Date: WORK ORDER NON-CONFORMANCE / UPDATE					TDART									
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Thursday, May 15, 2014 4:00:03 PM

Work Order ID: 119413

119413

Parent Item:

D3571-1

D3571-1

Parent Item Name: Guide

Start Date: 5/15/14

Required Date: 5/15/14

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 07-02-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50		- Purchased	No			100	f	60.9700	0.241	2.029474			

M6061T6B0 750X01 500

**

Location	Loc Qty	Loc Code	
MAT001	60.97		
- m126647	2.94		7.54 MM
m127818	8		130
- m128247	2.03		14/05/26
m128866	12		
m 129167	36		Not in computer

DQA:			Date:			WORK ORDER NON	c	SNICOI	DAMANCE / LIDE	NATE .				DART
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Work Orde	'' –					Rework			Skid-tube	Crosstube		Water Jet	Er	gineering
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			equence			Finish	L	Out of	Calibration					
			Fit/Function		Out of	Sequence								

DART AEROSPACE LTD	Work Order:	119413
Description: Guide	Part Number:	D3571-1
Inspection Dwg: D3571 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

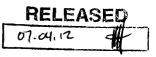
						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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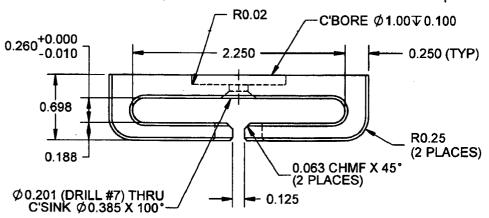
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Date:	14/03/29	Date:	14/05/30	Date:	N/A

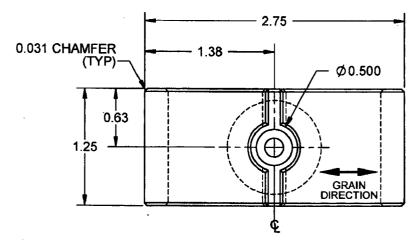
Rev	Date	Change	Revised by	Approved
Α	07.04.16	New Issue	KJ/JLM 🚓	
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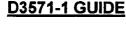
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Α	07,01.29	NEW ISSUE					













1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR AMS 4117/4128/4115/4116

OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3

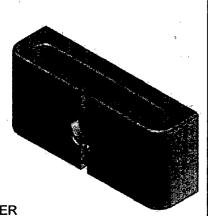
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) PART IS SYMMETRIC ABOUT &

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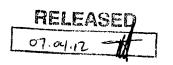
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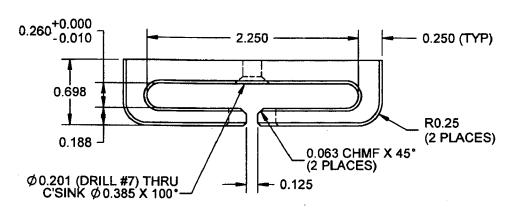
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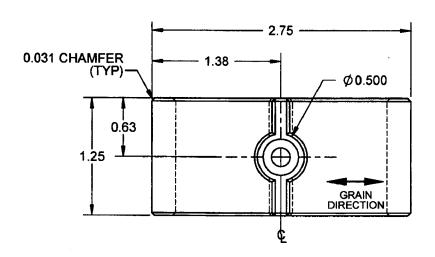
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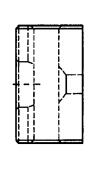


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D3571-3 GUIDE

NOTES

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

7) PART IS SYMMETRIC ABOUT &

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